

Work Order ID 157627

Thursday, March 16, 2017 3:55:12 PM

157627

Page 1

Item ID: D3825-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly (Basket End, Lid)
Start Date: 3/20/2017 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 3/23/2017 Req'd Qty: 8.00 ***8*** Customer:
Reference: SCHEDULED/C
Approvals: Process Plan:  Date: MAR 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	C								

100

0.00

1000

Large Fab

Large Fab

1.92

Large Fab

Memo

- 1- cut D3825-3 rib as per dwg D3825
- 2- drill hole (3/16") in D3825-3 using DT9822 jig and open to finish size as per dwg D3825
- 3- c'sink hole as per dwg
- 4- remove identification markings
- 5- deburr
- 6- weld D2327-1 spacer & D4021-9 bushing as per dwg D3825
A/R S.S. Rod Batch: M134942
- 7- grind bushing weld flush where indicated on dwg D3825
- 8- deburr if necessary

CS 8 17/03/20 C/L

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

DQA:

Date:

2017-04-05



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date:

APR 04 2017

Work Order update only ☐

Work Order: <u>157627</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3825-043</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>17-6370</u>		Scrap ☒		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
<u>17-6371</u>		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
Suspected Unapproved ☐		Large Fab ☒		Composite ☐	Supplier ☐				
Date: <u>17-03-24</u>		Step #: <u>100</u>		QTY Effective: <u>②</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			<u>DAS</u> <u>9</u> <u>9-89</u> <u>17-03-24</u>		
Qty 1 of D3825-043 was found to be too short. Operator cut part at 25.375 should be 25.500 Qty 1 of D3825-043 was found to be wrong material use. P.C. operator not second checking is work.				Scrap D3825-043 & no replace			Completed By <u>C. SM</u> <u>17/03/17</u>		
							Lead hand / Supervisor Approval Verification <u>DAS</u> <u>43</u> <u>9-89</u> <u>MAR 27 2017</u>		
							QC / QA Coordinator Approval <u>DAS</u> <u>9</u> <u>9-89</u> <u>17-03-24</u>		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	☒ Over/Under tolerance				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	☒ Wrong Stock Pulled	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 157627

Thursday, March 16, 2017 3:55:12 PM

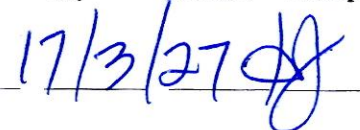
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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.80							
Quality Control									

17/3/27 

 MAR 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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		OTHER : ☐			

Picklist Print

Thursday, March 16, 2017 3:55:17 PM

Page 1

Work Order ID: 157627

157627

Parent Item: D3825-043

D3825-043

Parent Item Name: Rib Assembly (Basket End, Lid)

Start Date: 3/20/2017

Required Date: 3/23/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.07.24 AS PER REV.B DD VERF:EC IPP
REV:B 12.08.08 AS PER DWG REV.C DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-1

Manufactured

No

100

Each

32.0000

1

8

D2327-1

Spacer Bushing

**

Location

Loc Qty

Loc Code

WA004

32

155959

32

D4021-9

Manufactured

No

100

Each

192.0000

2

16

D4021-9

Bushing

**

Location

Loc Qty

Loc Code

WA004

192

145800

2

155371

190

M304TS0.750W.065

Purchased

No

100

f

1,042.804

2.125

17.89474

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

Location

Loc Qty

Loc Code

WA004

1042.804944

m133412

2.264944

m136378

93.54

m136907

147

m137065

800

CS

18.

DQA: _____ Date: _____



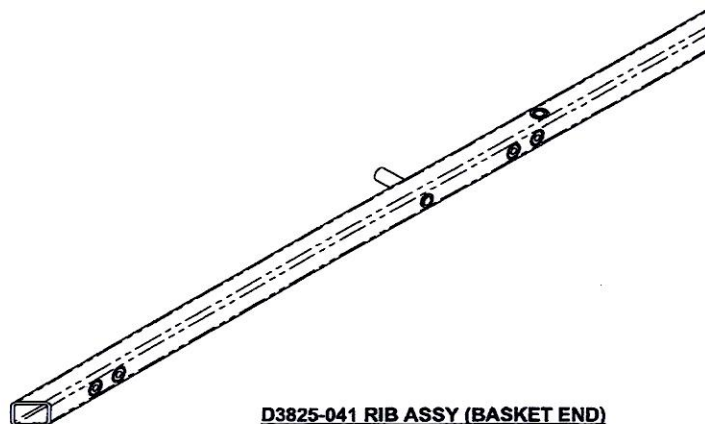
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

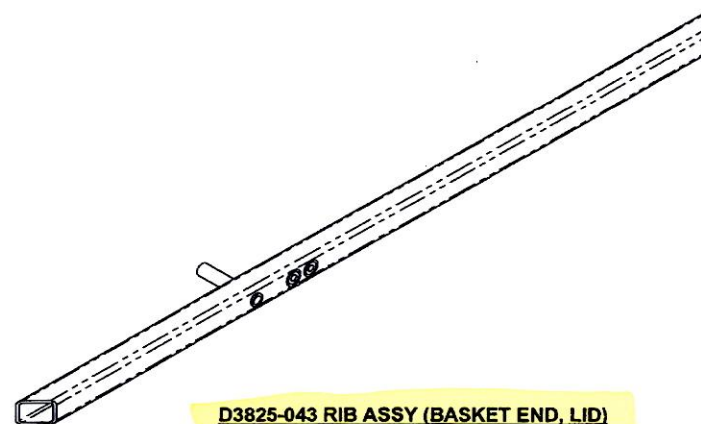
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3825-041	RIB ASSEMBLY (BASKET END)
		X	D3825-043	RIB ASSEMBLY (BASKET END, LID)
1		1	D2327-1	SPACER BUSHING
2	1		D2327-3	SPACER BUSHING
3	1		D3759-1	BUSHING
4	1		D3825-1	RIB
5		1	D3825-3	RIB
6	4	2	D4021-9	BUSHING



D3825-041 RIB ASSY (BASKET END)



D3825-043 RIB ASSY (BASKET END, LID)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157627

MAR 16 2017

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3825-041 = 1.27 lbs; D3825-043 = 1.23 lbs
- 8) WELDING: PER DART QSI 004

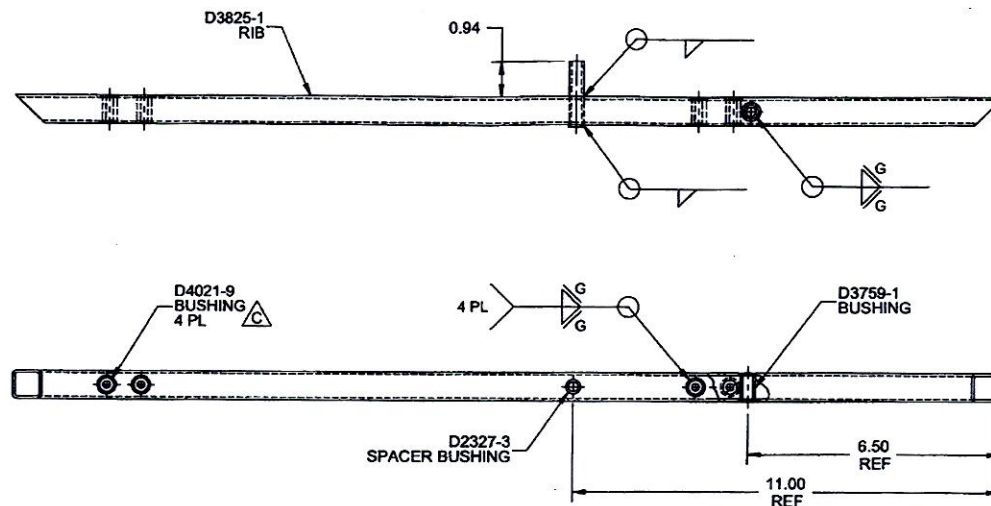
RELEASED
2012-08-03

C	QTY(4) D4021-9 ON -041 AND QTY(2) D4021-9 ON -043 WERE D3759-1. CORRECTED DIM (ZN B3-4): WAS 14.875. REASON FOR CHG: ANS SIZE BOLTS REQ'D IN THOSE LOCATIONS.	MB	12.07.18
B	QTY(5) FOR D3759-1 WAS QTY(1): AFFECTS D3825-041/-1 (ZNS D3-1, C4-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED D3825-043/-3. REASON: PAR10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	1/1		
DRAWN	1/1		
CHECKED	AP		
MFG. APPR.	1/1		
APPROVED	1/1		
DE APPR.	1/1		
DATE	12.07.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3825
REV. C
SHEET 1 OF 4
SCALE NTS
TITLE RIB ASSY (BASKET END)

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D3825-041 RIB ASSY (BASKET END)

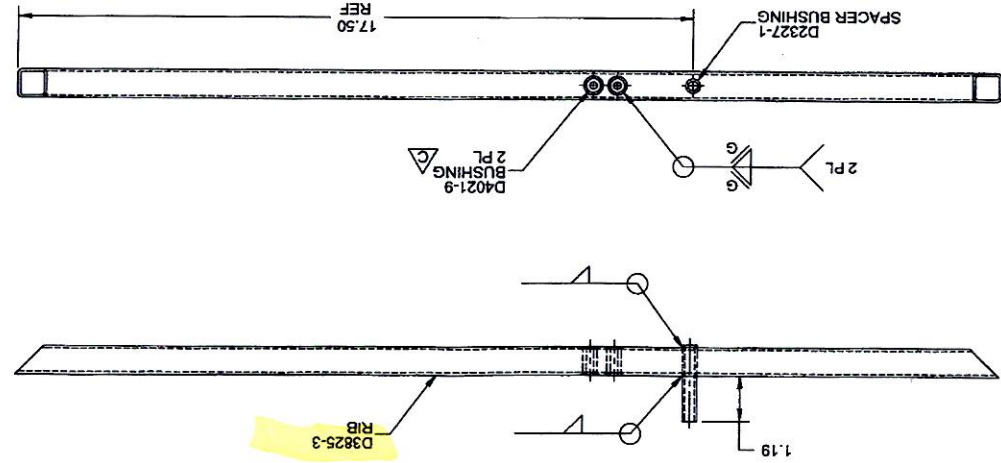
RELEASED
2012-08-03
JMP

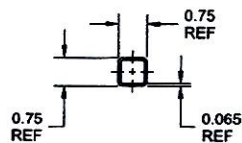
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DESIGN	DATE	12.07.18
DRAWN	DE APPR.	
CHECKED	APPROVED	
DRAWING NO.	MFG. APPR.	
D3825		
REV. C		
SHEET 3 OF 4		
SCALE		
RIB ASSY (BASKET END)		
DART AEROSPACE LTD		
HAWKESBURY, ONTARIO, CANADA		

RELEASE
2012-08-03

D3825-043 RIB ASSY (BASKET END, LID)





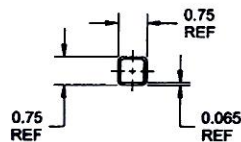
0.75 X 45°
CHAMFER
TYP

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU
 $\varnothing 0.49 \times 100^\circ$ CSK
ON BOTH SIDES

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU
 $\varnothing 0.49 \times 100^\circ$ CSK
4 PL, ON BOTH SIDES

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

D3825-1 RIB



0.75 X 45°
CHAMFER
TYP

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU
 $\varnothing 0.49 \times 100^\circ$ CSK
2 PL, ON BOTH SIDES

$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

D3825-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	12-07-18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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